

Thursday, 22/01/2009 7:55:42 AM
 Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LONGITUDINAL SUPPORT ASSEMBLY
Job Number	: 45028		
Estimate Number	: 13524		
P.O. Number	:	Part Number	: PB674300145
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.13
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 41380	Material	:
Written By	:	Due Date	: 28/01/2009 Qty: 9 Um: Each
Checked & Approved By	: <u>MF 09-01-22</u>		
Comment	: Est Rev:A 08-07-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	240107	SPRING SLOTTED PIN
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

SPRING SLOTTED PIN

batch: 17850MF 09-02-12

2.0	PB674300197	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

Clevis

batch: 3 x 23985, B 41869 x 6 mxMF 09-02-12

3.0	PB6743001357	Tube Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

Tube Arm

batch: 41232 x 5, B 41508 x 4MF 09-02-12

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- line drill -97 and -357 using existing pilot hole of -357 as per dwg

2- install spring pin

SP 09.02.18 (94)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

2092.15 (9)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 7:55:42 AM
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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M102316



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

8:20am

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:50am

HP 09-02-27 (9)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 09/02/27 (9)

8.0

D34475

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Clevis

batch: 41221

SS 09/02/27 (9)

9.0

D34471

Round Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Round Spacer

batch: 41458

SS 09/02/27 (9)

10.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

batch: 110865

SS 09/02/27 (9)

11.0

NAS1149F0432P

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

batch: M18057

SS 09/02/27 (9)

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: 109282

SS 09/02/27 (9)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-45 PAR #: 09-011 Fault Category: Engineering Design NCR: Yes ☒ No ☐ DQA: ND Date: 09/03/12
 Resolution: Documentation Revised Disposition: Re-work QA: N/C Closed: _____ Date: _____

NCR: <u>45028</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.03.05	8.0	HOLE ON D3447-5, OR HOLES ON B67-43001-57 DRILLED IN WRNG LOCATION. R.C. DWG NOT CLEAR.	↓ 09.03.05 PER GS102	ALIGN D3447-5 ON B67-43001-57 AND TRANSFER DRILL Ø0.250" HOLE FROM B67-43001-57 TO D3447-5.	Cpl 09.03.05	↓ 09.03.11	↓ 09.03.05 GS1 OR	↓ 09.03.11
		Done on previous w/o.		PAR 09-011.				
09.03.05	9.0	BOTTOM HOLE NOT ALIGNED WITH CLEVIS HOLE WHEN REWORK ADDING D3447-1 SPACER. R.C. DWG	↓ 09.03.05	ADJUST SPACER LENGTH BY GRINDING OFF TOP OR BOTTOM EDGE. TACK PAINT	Cpl 09.03.05	↓ 09.03.11	↓ 09.03.05	↓ 09.03.11

NOTE: Date & initial all entries

NOT CLEAR.

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS17984C410

QUICK PIN REPLACEMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

QUICK PIN REPLACEMENT

batch: M109739

SS 09/02/27 (x9)

14.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

LANYARD

batch: M17828

SS 09/02/27 (x9)

15.0

BSP43

RIVET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

RIVET

batch: M109119

SS 09/02/27 (x9)

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Washer

batch: M6085

SS 09/02/27 (x9)

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble parts as per dwg PB67-43001

M-h

09/03/06 (9X)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/03/06 (x9)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST - Blade Fold section

MR 09-03-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/11 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

